

Work Order ID 83952

Monday, April 30, 2012 10:59:27 AM

83952

May 25th

Page 1

Item ID: D3915-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Light Lid Assembly, Long Basket

Start Date: 5/4/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/24/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *umf*

Date: *12-04-30* Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3915

C

100

Weld per dwg A/R Aluminum rod Batch: *119185* 0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs, weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

*****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

1 *11*

12-05-23

710

1 *8* *BE12/13/20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3915-241 PAR #: _____ Fault Category: Large Part (welds) NCR: Yes No DQA: OK Date: 12/06/07
 Resolution: Scrap Disposition: Scrap Re-work QA: N/C Closed: OK Date: 12/6/08

NCR: <u>12-1470</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>##?</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>12/05/08</u>	<u>#100</u>	<u>End scrap due to spacing in D2957 is too narrow 1125 should be 1.2501. R/L LGA (welds) & D2957</u>	<u>12/05/31</u>	<u>Scrap + Destroy + Replace New Batch</u> <u>D2957 = 83468 = 4</u> <u>D40165 = 84825 = 3</u> <u>D3915-1 = 84232 = 2</u>	<u>12.05.31</u>	<u>S</u> <u>12/05/31</u>	<u>12.05.31</u>	<u>S</u> <u>12/05/08</u>
		<u>Alt to how spacers were installed</u>		<u>4019-3 = 83798 = 1</u> <u>68605 = 2</u> <u>4035-245 = 84688 = 1</u> <u>4035-247 = 71225 = 1</u> <u>4056-1 = 84846 = 2</u>				<u>S</u> <u>12/05/26</u>

NOTE: Date & initial all entries

Work Order ID 83952

Monday, April 30, 2012 10:59:27 AM

83952

Page 2

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Light Lid Assembly, Long Basket
Start Date: 5/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/24/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5/26/12					Plat
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***	0.00 0.00							26/12-5-29
140 *140* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 119785 Memo 1- weld (4) corners	0.00 0.00							12-05-29

W/O: 43952		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3915-041 PAR #: _____ Fault Category: Large PAB (weldin) NCR: Yes No DQA: Aut Date: 12/06/11
 Resolution: Reswork Disposition: Reswork QA: N/C Closed CK Date: 12/6/12

NCR: 12-1489		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/26	#100	Found at inspection that the label plate was welded in the incorrect location R/L LOA. welder don't look at Day.	↓ 120526 Q51042	cut w/d + scrap label plate Grind welds flush, don't damage ribs. Re weld D as per Eng.	12-05-28	S 12/05/29	↓ 120526 Q51042	S 12/6/28

NOTE: Date & initial all entries

Work Order ID 83952

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Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 5/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/24/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00				1	0		BE 12/05/29
Quality Control									
155	QC6- Inspect dimensions to drawing	0.00							
155									
QC	Memo	0.00							
Quality Control	***inspect fit of lid with base***								
157	Chemical Conversion Coat per QSI005 4.1	0.00							
157									
HandFinish	Memo	0.00							
Hand Finishing	1- realodine corners ***do not acid etch***								

M-L
12/05/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83952

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Monday, April 30, 2012 10:59:27 AM

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 5/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/24/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo 1- touch up corner with alodine only 2- Plug holes prior to 1ST COAT: <u>10:50</u> START TIME: <u>3200 F</u> OVEN TEMPERATURE: <u>3200 F</u> FINISH TIME: <u>11:20</u> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				<u>1X</u>			<u>M.L.</u> <u>12/05/29</u>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>1X</u>			<u>ES</u> <u>12/05/30</u>

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83952***83952***

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Item ID: D3915-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Light Lid Assembly, Long Basket

Stop ***NS2***

Start Date: 5/4/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/24/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

MC 12/05/30

MF
12-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 30, 2012 10:59:26 AM

Page 1

Work Order ID: 83952

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 5/4/2012

Required Date: 5/24/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957 Mounting Plate		Manufactured	No			100	Each	24.0000	4	SAD ⁴		12-05-17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		24							
				71221		9							
				82668		15							
D3915-1 Rib		Manufactured	No			100	Each	4.0000	2	(3)+4	2	12-05-23	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006 B84232		4							
				73204		4							
D4016-5 Hinge Half, Light Lid		Manufactured	No			100	Each	9.0000	3	2+2	3	12-05-23	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005 B84225		9							
				66335		3							
				74468		6							
D4019-3 Rib		Manufactured	No			100	Each	11.0000	3	SAD ³		05-17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA B83798		6							
				63667		0							
				74467		6							
				WA006		5							
				68605		5							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Monday, April 30, 2012 10:59:26 AM

Page 2

Work Order ID: 83952

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 5/4/2012

Required Date: 5/24/2012

Start Qty: 1.00

Required Qty: 1.00

D4035-045

Manufactured

No

100

Each

5.0000

1

1

Lid Rib Assembly, Fwd (Light)

Location

Loc Qty

Loc Code

WA

63668

4

0

74466

4

WA006

1

68545

1

D4035-047

Manufactured

No

100

Each

6.0000

1

Lid Rib Assembly, Aft (Light)

Location

Loc Qty

Loc Code

WA006

6

71225

2

74809

4

D4056-1

Manufactured

No

100

Each

3.0000

1

Label Plate

Location

Loc Qty

Loc Code

WA005

3

70338

3

D2728-1

Manufactured

No

180

Each

0.0000

1

Dart Logo label

D4029-041

Manufactured

No

180

Each

3.0000

1

Webbing (Long Basket)

Location

Loc Qty

Loc Code

st503

3

69499

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 30, 2012 10:59:26 AM

Page 3

Work Order ID: 83952

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 5/4/2012

Required Date: 5/24/2012

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

180

Each

1,104.0000

34

34

Cherry Rivets

Location

Loc Qty

Loc Code

ST321

971

111636

36

117601

3

118626

592

120308

340

WA018

133

107939

133

NAS1149DN416J

Purchased

No

180

Each

215.0000

34

34

Washer

Location

Loc Qty

Loc Code

ST297

215

114348

11

114597

119

13910

85

Monday, April 30, 2012 10:59:26 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

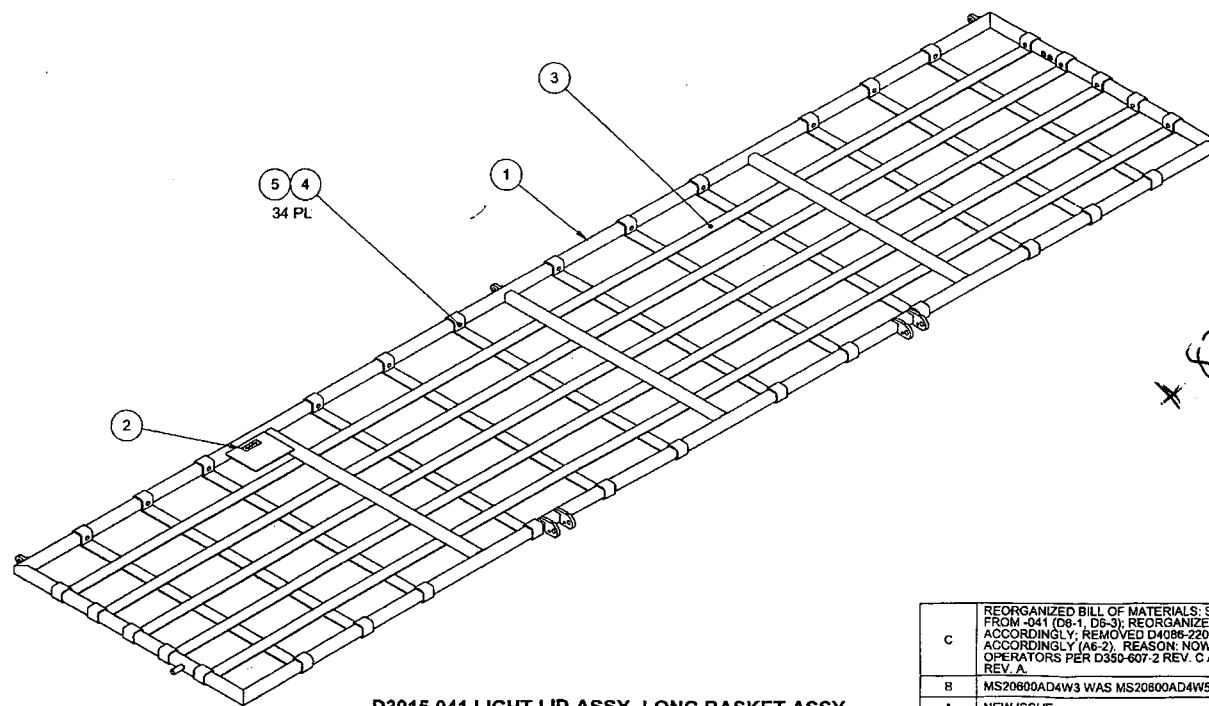
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	MS20600AD4W3	BLIND RIVET
5	34	NAS1149DN416J	WASHER



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

C		REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D8-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-220; UPDATED VIEW E ACCORDINGLY (A6-2); REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.		MB	10.08.05
B		MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)		JPH	10.04.06
A		NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION			BY	DATE
DESIGN	HLS			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HLS			DRAWING NO. D3915 REV. C	
CHECKED	HLS			SHEET 1 OF 4	
MFG. APPR.	HLS			TITLE SCALE	
APPROVED	HLS			LIGHT LID ASSY-LONG BASKET NTS	
DE APPR.	HLS			COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.08.05			THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
10.08.12
ECN 10-546

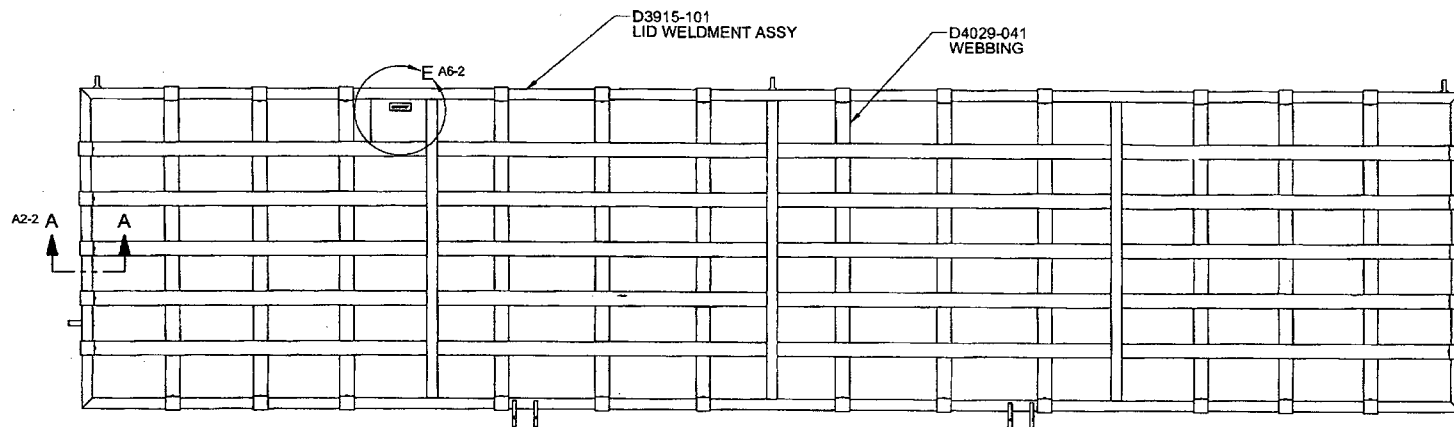
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

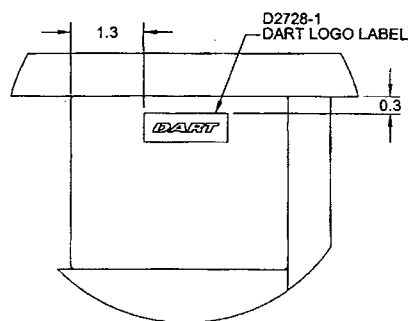
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

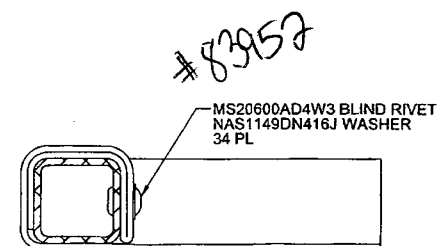
NOTE: Date & initial all entries



D3915-041 LIGHT LID ASSY, LONG BASKET



VIEW E D6-2



SECTION A-A C6-2

RELEASED
10.08.17

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D3915	REV. C
MFG. APPR.	ALS	SHEET 2 OF 4	
APPROVED	ALS	SCALE	
DE APPR.	ALS	LIGHT LID ASSY-LONG BASKET INTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

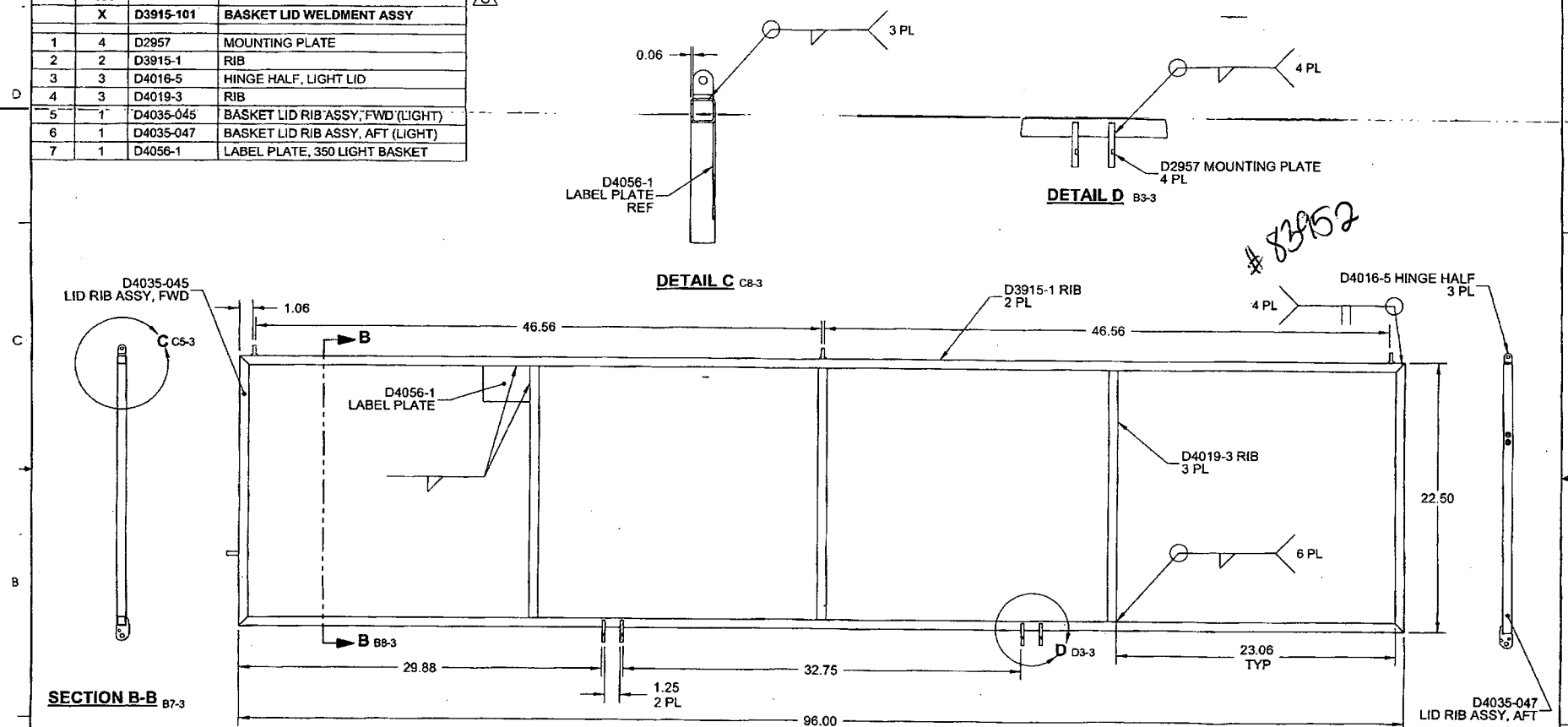
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	2	D3915-1	RIB
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



SECTION B-B B7-3

D3915-101 BASKET LID WELDMENT ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.81 lbs
- 8) WELD PER DART QSI 004

DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. C
CHECKED	SC	D3915	SHEET 3 OF 4
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AS	LIGHT LID ASSY-LONG BASKET	INTS
DE APPR.	AS	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

RELEASED
10.08.12 QP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Technical drawing of a 45° 2PL assembly. The drawing includes a side view and a cross-section view.

Side View Dimensions:

- Overall length: 96.00
- Reference length: 94.50 REF
- Segment lengths: 6.31, 12.00, 29.11, 52.89, 77.69, 14.00, 12.00
- Pitch values: 6.00 PITCH, 7.00 PITCH

Cross-section View Dimensions:

- Thickness: 0.062 REF
- Internal feature: 0.0125 THIS FACE ONLY 12 PL
- Overall width: 0.75 REF

Handwritten note: x83952

RELEASED
10.01.12 CP

1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF ADQ SPEC. M6081T6TS0.750W.062

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.49 lbs

DESIGN	415	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.		D3915	SHEET 4 OF 4
DE APPR.		TITLE	SCALE
DATE	10.08.05	LIGHT LID ASSY-LONG BASKET INTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries